



Dart Aerospace Ltd.
1270 Aberdeen St
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RB23003267
Job Sheet 193987



Part No: RB23003267

Job Qty: 2 pcs

Part Name: Power Turbine Support Cleaning C-18, C-20 & C-28



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 6/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *only 15587*

Note: DWG RB23003267 Rev.4 IPP Rev. A 19.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	6/18/19		0.00	0.25	Small Fab - 1		<i>MLC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	6/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
120	QC	2 pcs	6/18/19		0.00	0.00	QC 5 - 9		DAS 40 JUN 05 2019 9-89
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
130	Packaging 3-1 - Stock - B4B	2 pcs	6/18/19		0.00	0.00	Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S187699



Part: RB23003267

Job No: 193987

Serial No/Batch: S187699

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 06/05/19

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	6/18/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

JAM

GASIA

DAS
21
9-55

JUN 05 2019

Part Op 100 - Pick and pack as per drawing.

Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
K206	Flambeau Plastic Box (Clean Out)	2 Ea (1 ea)	100-Small Fab - 1	5127655
PAD210	Foam Ø1 X 1 replace item 1887T48	.4440 sf (.222 ea)	100-Small Fab - 1	5021250
RB23003267-1	Clean Guide	2 pcs (1 ea)	100-Small Fab - 1	5165940
RB23003267-11	#12 Drill Bit & Block Assembly	2 pcs (1 ea)	100-Small Fab - 1	5185268
RB23003267-13	Hack Saw Blade-6"	2 pcs (1 ea)	100-Small Fab - 1	5156689
RB23003267-3	#56 Drill Bit & Block Assembly	2 pcs (1 ea)	100-Small Fab - 1	5185252
RB23003267-5	#52 Drill Bit & Block Assembly	2 pcs (1 ea)	100-Small Fab - 1	5185258
RB23003267-7	#27 Drill Bit	2 pcs (1 ea)	100-Small Fab - 1	5185263
RB23003267-9	#22 Drill Bit & Block Assembly	2 pcs (1 ea)	100-Small Fab - 1	5185266
RB23007615-15	Wire	8 ft (4 ea)	100-Small Fab - 1	5097885

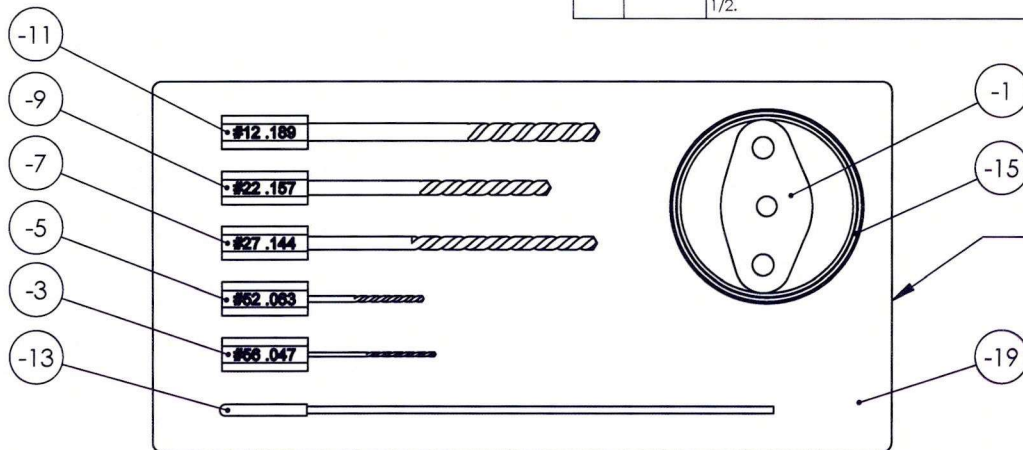
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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	K206	2	11	0
	PAD210	0	1	0
	RB23003267-1	2	4	0
	RB23003267-11	2	0	0
	RB23003267-13	2	4	0
	RB23003267-3	2	0	0
	RB23003267-5	2	0	0
	RB23003267-7	2	0	0
	RB23003267-9	2	0	0
	RB23007615-15	8	144	0
Part Specifications				
Specifications could not be found.				

Plex 4/24/19 3:09 PM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED MODEL USED ON FROM ALLISON, & DELETED ENGRAVE NOTE.	11/3/2006	-	-
1A		CH'D TITLEBLOCK & REVISION BLOCK, ADDED DWG. FOR CASE, FOAM INSERT, & ASSY.	8/11/2009	RJC	RW
1B		-1 CH'D DIMS WAS R.750 IS R.75, WAS R1.000 IS R1.00, ADDED NOTES IN BOM FOR -3, -5, -7, -9, -11, -13 MOVED TO SEPARATE SHEET, CH'D DIMS WAS 12.000 IS 12.00, WAS 6.000 IS 6.00.	2/4/2014	DPD	RJC
4	16-0024	UPDATED TO NEW STANDARDS, DELETED RED BARN STICKER FROM BOM. ADDED STICKER NOTE, ADDED PART OF KIT NOTE. -1 CH'D DIM WAS Ø.219 THRU CHAMFER .025 X 45° IS Ø.219 THRU ALL V/ Ø.27 X 90°. -2 DELETED FROM BOM. -3A, -3B, -5A, -5B, -7A, -7B, -9A, -9B, -11A, -11B ADDED TO BOM & ADDED DRAWINGS. -3B, -5B, -7B, -9B, -11B CH'D DIM WAS .935 IS .94. -13 CH'D QTY WAS 1 IS 1/2.	2/8/2016	DPD	JAG



ADD STICKER W/ DART LOGO,
P/N, REV, & JOB NUMBER
TO SIDE OF CASE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193987MLW
1904-25

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
						-1	1	GUIDE	6061		2
				X		-3	1	#56 DRILL BIT ASSEMBLY			3
				1		-3A		#56 DRILL BIT	STEEL	#56 (ARONSON CAMPBELL #AC40156) MODIFIED	4
				1		-3B		BLOCK	2011		5
			X			-5	1	#52 DRILL BIT ASSEMBLY			6
			1			-5A		#52 DRILL BIT	STEEL	#52 (ARONSON CAMPBELL #AC40152) MODIFIED	7
			1			-5B		BLOCK	2011		8
		X				-7	1	#27 DRILL BIT ASSEMBLY			9
		1				-7A		#27 DRILL BIT	STEEL	#27 (ARONSON CAMPBELL #AB51127) MODIFIED	10
		1				-7B		BLOCK	2011		11
	X					-9	1	#22 DRILL BIT ASSEMBLY			12
	1					-9A		#22 DRILL BIT	STEEL	#22 (ARONSON CAMPBELL #AC40122) MODIFIED	13
	1					-9B		BLOCK	2011		14
X						-11	1	#12 DRILL BIT ASSEMBLY			15
1						-11A		#12 DRILL BIT	STEEL	#12 (ARONSON CAMPBELL #AC40112) MODIFIED	16
1						-11B		BLOCK	2011		17
						-13	1/2	SAW	STEEL	(BESTWAY PRODUCTS #HAC5012BX) MODIFIED	18
						B/O -15	1	SAFETY WIRE	S.S.	Ø.041 X 48 WRAPPED AROUND 1-7/8 ARBOR	1
						B/O -17	1	CLEAR PLASTIC CASE	PLASTIC	(FLAMBEAU #K206 OR EQUIVALENT)	N/S
						B/O -19	1	CRAFT FOAM	FOAM	1 X 4 X 8	1
ASSY -11	ASSY -9	ASSY -7	ASSY -5	ASSY -3							

NOTE:
1. USED ON ROLLS ROYCE C20 OIL NOZZLE & SUMP.
2. PART OF KIT RBT18510.

DART
AEROSPACE

TITLE
POWER TURBINE CLEANING KIT

DWG NO.	RB23003267	REV	4
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/		
HEAT TREAT			
FINISH			
SPEC			
DRAWN BY:	CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
CHECKED:	CLOUGH		
OPPS APPR:	ANDERSON		
QA APPR:	LINDSAY		
APPROVED:	GILBERT	USED ON MODEL	
SCALE	1:2	DATE	1/17/2001
		SHEET 1 OF 18	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					